Work Orde February-21-13				*976	889*							Page 1
Revision ID:	D3912-3 Eyebolt Block	527.	A	Accept	*N900	<b>040</b>	100	)* 5	Setup	Start Stop	*N!	S1* S2*
	2/26/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:						
Approvals:	Process Pla	nn: MO	Date: <u>13-02-25</u>	Tooling: SPC (Y/N):		ite:		]	Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center II	)	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3912	В											
*100 *100* Bandsaw	10.10	Cut blanks as per folio  Memo		0.00				12				1 /3-3-3
Jeaspa Bandsaw		CUT BLAN	K 2.50" LONG		:							
110				0.00				10				OAS
*110* HAAS 1		Memo		0.00				12-				5 6 5
HAAS CNC vertica	I machine #1			D DWG								

DEBURR

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	·
Part No					Rework Scrap Use-as-is		Skid-tube  Machining  moforming	Crosstube Small Fab Finishing	•	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No		····			Work Order Update		Large Fab	Composite	:	Supplier	
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling		į				i					
Operator											
Material								į			
Setup											
Other										1	
Process											
Supplier											
Training											
Unapproved											
<u> </u>					FA	AULT CATE	GORY				

Landing G	Gear	General	_	_	
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		 
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde February-21-13				*976	389*						Page 2
tem ID: Revision ID: Item Name:	D3912-3 Eyebolt Block			Accept	*N900	<b>040</b>	100	)* s	Setup Star	171	S1* S2*
	2/26/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:					
Approvals:		n:		Tooling: SPC (Y/N):		ite:		I	Run Star Sto	" <b> V</b>	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC2- inspect parts off ma	achine FAI/FAIB	0.00							DA(9) 25)
130 *130*	•	QC8- Inspect parts - seco	and check	0.00	= H_ 13/03/	104		17	Ø		
QC Quality Control		Memo		0.00	,			_/_			
<sup>160</sup> *16Ո*		Identify as per dwg & Sto	ock Location: <u>ST14</u> 4	0.00				1	2 .		13-03-05
Packaging		Memo		0.00					<u> </u>		

Memo

Packaging

NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
Part N	•					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fal noforming Finishing Large Fab Composite	g		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		·			Descri	ption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY			· · · · · · · · · · · · · · · · · · ·	· — · · · · · · · · · · · · · · · · · ·
Landi		1			_	General		1 .		_	1	_	<b>1</b>
	-	Bending Centre No	nt Canca	ntric to		Bend BOM/Route	-	Grain Hardwa	uro.	$\vdash$	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	$\vdash$	Cracks	Ji Concei	THE LO	",  -	Broken/Damaged		1	ion Incomplete	-	Part Incorre	<b>⊢</b>	Weld
		Crushed/	Crimped.			Burrs		-l '	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ordo</b> February-21-13				*976	389*							Page 3	
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Block	·		Accept	*N900	<b>040</b>	100	*	Setup	Start Stop	1 41	S1* S2*	
Start Date: Required Date: Reference:	2/26/13 : 3/08/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:				<b>0</b>			
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center I	D	Operation Description OC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp	
*170*		Мето		0.00						13/	3/6	#	

Quality Control

Q1305.5

											DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C		NFOR!	AANCE / UPDA		0466			
							1				QA Closed:	Dat	e:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Machining of orming of orming of orming of orming of the ormina of the o	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root			T	I	Descri	tion of work order update		Initial	Actio	n	Sign &			
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng	Descrip		Date	Verification	,	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						<del>- ''</del>	AUL	T CATE	GORY					
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/Un nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	1	Ripples in	Bend		l	Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# **Picklist Print**

February-21-13 12:40:27 PM

Work Order ID:

97689

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

**Start Date: 2/26/13** 

Required Date: 3/08/13

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	20.5783	0.208	2.6273688	5/	13.3.	.3

 Location
 Loc Oty
 Loc Code

 MAT049
 20.5783

 124081
 20.5783

2.7

									DQA:	Date:	
NCR: Y€	es / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	0				Rework Scrap Use-as-is Work Order Update	ļ	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator							•				
Material											
Setup											
Other											
Process											
Supplier										1	

#### Bend Grain Ovalized Pressure/Forced Bending BOM/Route Temperature/Cure Centre Not Concentric to O/S Hardware Over/Under tolerance Cracks Broken/Damaged Weld Inspection incomplete Part Incorrect Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped. Burrs Cuffs Maintenance Contamination Part Moved Countersink Mislabeled Positioned Wrong **Heat Treat** Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Out of Sequence Finish Folio Wave/Twist in Tube Outside Dimensions

**FAULT CATEGORY** 

General

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Training Unapproved

**Landing Gear** 

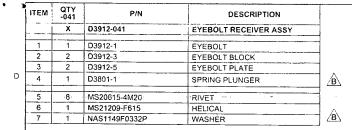
DART AEROSPACE LTD	Work Order:	97689
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

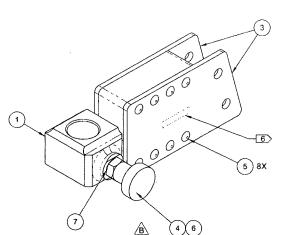
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.30	+/-0.030	2.301	//		Uem JK-M	
Ø0.129	+0.005/-0.001	-128				
0.50 Ref	+/-0.030	497			\	
R0.13	+/-0.030	-130			(	<u> </u>
0.500	+/-0.010	493			,	
R0.125	+/-0.010	-125			(	1
0.63	+/-0.030	-625			ı	
0.750	+0.000/-0.020	138			\	
0.38	+/-0.030	378	/		,	
1.500	+/-0.010	1.500				
0.500 Pitch	+/-0.010	500				
0.800	+0.000/-0.010	193	/_			
0.400	+/-0.010	397	/_			
0.516	+0.015/-0.000	-520	//			
1.00	+/-0.030	991				
		·			1	
	,					
				·····		
				**************************************		
						·

Measured by:	SL	Audited by:	秋	Preliminary Approval:	
Date:	13-04-5	Date:	13/03/04	Date:	

Rev	Date	Change	Revised	by	Approved
Α	10.06.07	New Issue	KJ	ιΛ	1
В	12.05.15	Dwg Rev updated	KJ	ALL	(WIII
				7	7



MI RECEY JUPNTO ENGINDERING UNCONTROLLED COPY TOUT TO AMENDMENT Mill's LPOILCE 97685\_MC5 1302-25



SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

### **D3912-041 EYEBOLT RECEIVER ASSY**

NOTES: 1) MATERIAL: N/A 2) FINISH: NONE

С

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER

7) WEIGHT -041: 1.58 lbs

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10.06.28 JPH 10.03.04 Α DESCRIPTION BY DATE

REV. DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. D3912 MFG, APPR. TITLE **APPROVED** DE APPR. DATE 10.06.28

SCALE **EYEBOLT RECEIVER ASSY** 

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ED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON

REV. B

NTS

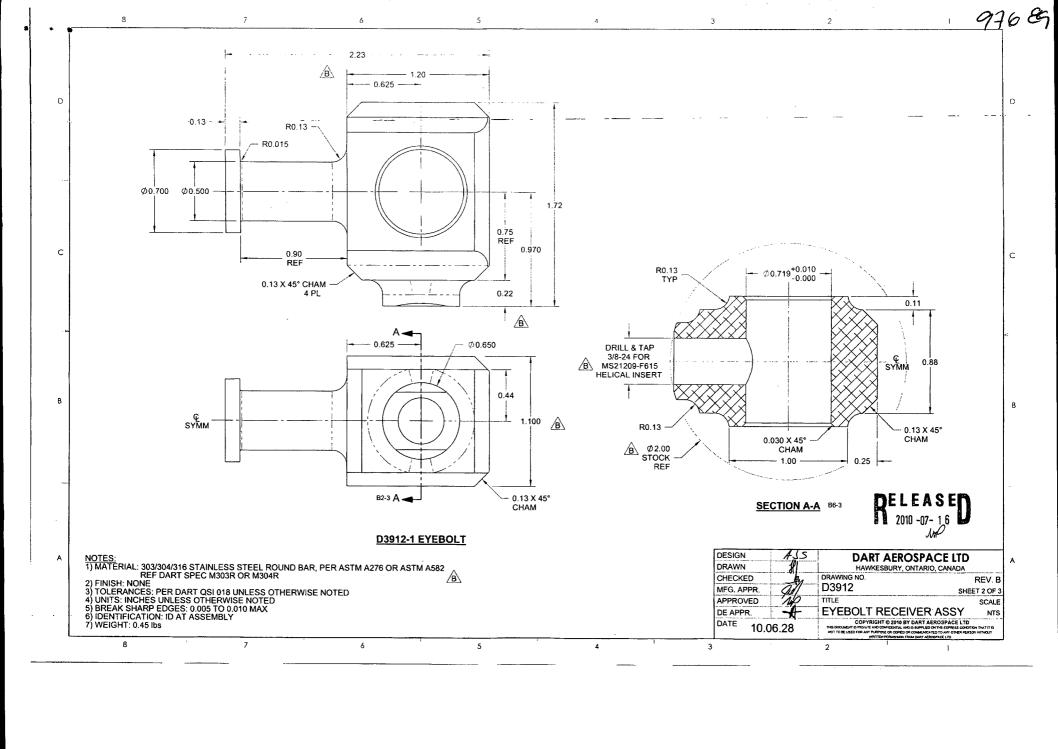
SHEET 1 OF 3

5

8

6

4



0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL - 0.400 -0.500 PITCH 0.50 REF 1.00 0.750 +0.000 -0.020 0.500 R0.13 R0.125 TYP 0.516+0.015 0.63

## **D3912-3 EYEBOLT BLOCK**

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

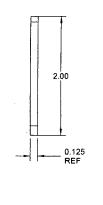
- -5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

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С

- 2) FINISH: NONE
  3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  6) IDENTIFICATION: ID AT ASSEMBLY
  7) WEIGHT -3: 0.30 lbs
  -5: 0.24 lbs

3.15 1.500 0.500 PITCH √0.375 R0.13 - 0.38 0.25 0.517 1.000 1.500 +0.020 105° REF Ø0.129 Ø0.257 8 PL 2 PL 3.65 3.69 REF



### **D3912-5 EYEBOLT PLATE**

DESIGN DRAWN	45S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	40	DRAWING NO.	REV. B	
MFG. APPR.	Qu/	D3912 <sub>SHE</sub>	ET 3 OF 3	
APPROVED	119	TITLE	SCALE	
DE APPR.	-#-	EYEBOLT RECEIVER ASSY	NTS	
DATE 10.0	06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCAMON IS MANATE AND COMPREHEN, AND IS SUMPLED ON THE COPPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY AMPRODE ON COMPLED ON COMMENTED TO MAY FORMER PERSON HYPHOLYT WINTEDN PERMISSION FROM DART AEROSPACE LTD		

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